

Date: Wednesday, 30/01/2008 7:52:08 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR AFT RH
Job Number : 37111	
Estimate Number : 11235	
P.O. Number :	Part Number : D32814
This Issue : 30/01/2008 S.O. No. :	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : THERMOFORMING	Drawing Revision : B
Previous Run : 35249	Material :
Written By :	Due Date : 06/02/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev A 04.07.01 New issue KJ/JLM	
Est Rev B 07.08.07 Thermoform in house DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6006 701	lexan black
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Comment: Qty.: 4.0000 sf(s)/Unit Total : 8.0000 sf(s)
 lexan black

M106957

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/01/30

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 010

Dwg. Rev. CFolio Rev. B

BB 08/01/30 x2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/01/30

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

OK 08/01/30.

x2,

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/01/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/01/2008 7:52:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 37111

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

x2

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

DL 08.01.30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 08.01.30 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

266 8/1/30 50 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) DL 08.01.30

Job Completion



DL 08.01.30

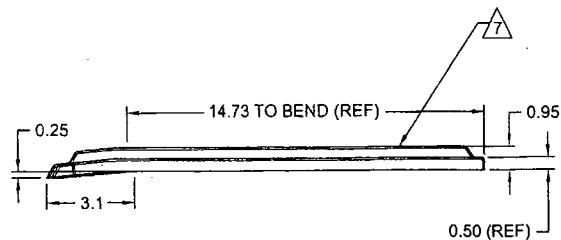
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

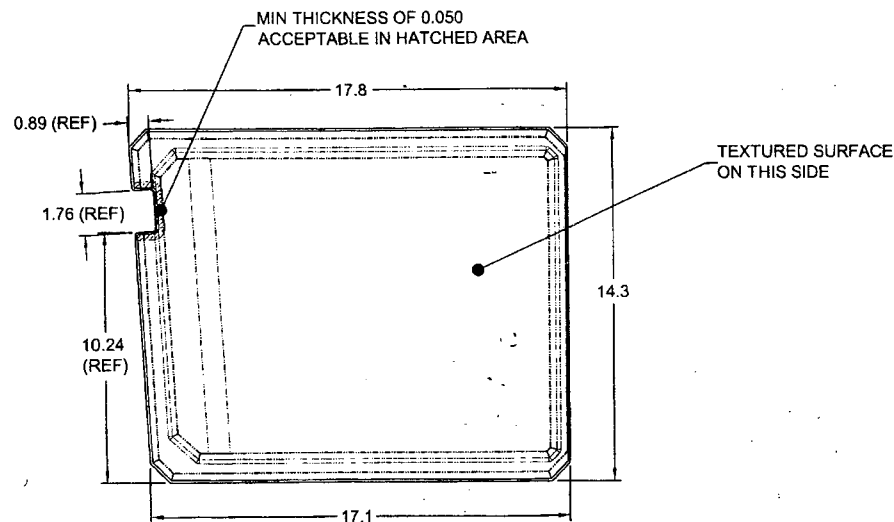
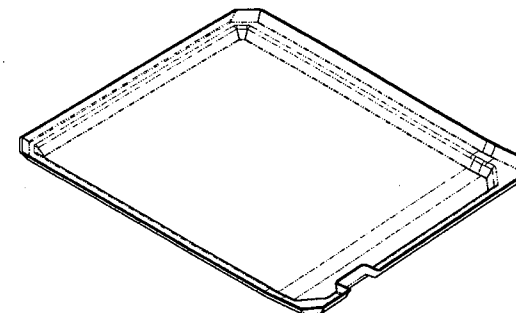
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



11/11/09



RELEASED
07-11-06

D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO.	REV. C
MFG. APPR.	W	D3281	SHEET 3 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	WORK ORDER:	37111
Description: 244 FLOOR PROTECTOR AFT RH	Part Number:	D32814
Inspection Dwg: D3281 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	BB
Acceptable shape definition	BB
Acceptable texture retention	BB
Free of visual flaws (bumps, cracks, voids, etc.	BB

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. C and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	.1	17.75	✓			
17.1	.1	17.1	✓			
14.3	.1	14.25	✓			
0.95	0.95	0.953	✓			

Measured by: <u>SK</u>	Audited by: <u>S</u>	Prototype Approval: <u>n</u>
Date: <u>08.01.30</u>	Date: <u>08.01.30</u>	Date: <u>7</u>

Rev	Date	Change	Revised by	Approved
		New Issue		